

# Work Order ID 56548

March 1, 2010 10:19:54 AM

ASAP



Page 1

Item ID: D3197-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar Assembly

Start Date: 3/01/10 Start Qty: 4.00



Cust Item ID:

Required Date: 3/02/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: 

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3197

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 29.125" long

DJP  
10/03/02

2

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Face ends to length per dwg D3197-12-Machine D3197-1 as per Folio FA340 and Dwg D3197-13-Deburr

DJP  
10/03/02

2

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DJP  
10/03/02

2

**Work Order ID 56548**

Page 2

March 1, 2010 10:19:55 AM

Item ID: D3197-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar Assembly

Start Date: 3/01/10 Start Qty: 4.00



Cust Item ID:

Required Date: 3/02/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Lathe Conv

Conventional Lathe

CONVENTIONAL LATHE

Memo

Chamfer as per Dwg D3197

0.00

0.00

J.F.S.

10/03/02

140



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

10.03.02

2

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

10-3-2

# Work Order ID 56548

March 1, 2010 10:19:55 AM



Page 3

Item ID: D3197-041

Accept



Setup Start



Revision ID:

Item Name: Bar Assembly

Stop



Start Date: 3/01/10

Start Qty: 4.00



Cust Item ID:

Required Date: 3/02/10

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



M112588

Powdercoat

Memo

0.00

Powder Coating

START TIME:

2:45pm

FINISH TIME:

DOVEN TEMPERATURE:

320°F

=> 10/03/02 (x2) φ

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 10-3-2

(2)

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3197-041 as per Dwg D3197

10/03/03 (2)

**Work Order ID 56548**

March 1, 2010 10:19:56 AM



Page 4

Item ID: D3197-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Bar Assembly

Start Date: 3/01/10 Start Qty: 4.00



Cust Item ID:

Required Date: 3/02/10 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	8/6/03/03			42			
200  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00 0.00							
210  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

C443/3 (2)

10/03/05

MF

10-3-3

# Picklist Print

March 1, 2010 10:19:52 AM

Page 1

Work Order ID: 56548

Parent Item: D3197-041

Parent Item Name: Bar Assembly

Comments: IPP Rev: A New Issue 05-11-08 JLM  
IPP Rev: B As per Rev B 06-03-10 JLM

Start Date: 3/01/10

Required Date: 3/02/10

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10		Purchased	No			180	Each	0.0000	24.0000			
Washer												
D2690-5		Manufactured	No			180	Each	14.0000	8.0000			
Lanyard Assembly												

D3242-1		Manufactured	No			180	Each	0.0000	8.0000			
Tag												
D3489-3-200		Manufactured	No			180	Each	14.0000	8.0000			
PIP PIN												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST021	14	
37927	2	
46958	12	

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	14	
46991	14	

8/5/10/03/03  
4  
8/5/10/03/03  
4  
8/5/10/03/03

# Picklist Print

March 1, 2010 10:19:53 AM

Page 2

Work Order ID: 56548



Parent Item: D3197-041



Parent Item Name: Bar Assembly

Start Date: 3/01/10

Required Date: 3/02/10

Comments: IPP Rev: A New Issue 05-11-08 JLM  
IPP Rev: B As per Rev B 06-03-10 JLM

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M7075T73R1.000		Purchased	No			180	f	25.0100	10.1895			



7075-T73 Rd Bar 1.00

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

MAT	25.01	
100286	4.54	
106027	3.09	
106070	8	
111485	9.38	

MS21042L3

Purchased

No

180

Each

2,516.000

8.0000



Nut

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	2510	
110844	35	
111274	27	
111668	52	
112314	285	
112385	393	
113523	18	
113537	700	
113644	1000	

Main Warehouse

ST139	6	
111668	6	

5.0948 DTP 10/03/02

EP 10/03/03

March 1, 2010 10:19:53 AM

Shop Packet Print

Page 2

# Picklist Print

March 1, 2010 10:19:53 AM

Page 3

Work Order ID: 56548



Parent Item: D3197-041



Parent Item Name: Bar Assembly

Start Date: 3/01/10

Required Date: 3/02/10

Comments: IPP Rev: A New Issue 05-11-08 JLM  
IPP Rev: B As per Rev B 06-03-10 JLM

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-24		Purchased	No			100	Each	134.0000	8.0000			



Screw



*Ep 5/10/23/03*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

134

100151

134

4

March 1, 2010 10:19:53 AM

Shop Packet Print

Page 3

DART AEROSPACE LTD		Work Order:	56548
Description: Bar		Part Number:	D3197-1
Inspection Dwg: D3197 Rev: B		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	✓			
25.06	+/-0.030	N/A	✓			
11.44	+/-0.030	11.435	✓			
0.500	+/-0.010	0.500	✓			
0.250	+/-0.030	0.247	✓			
Ø0.219	+0.005/-0.000	0.219	✓			
Ø0.191	+0.005/-0.000	0.194	✓			
1.000	+/-0.005	1.000	✓			
2.69	+/-0.030	2.686	✓			
1.000	+/-0.010	1.000	✓			
0.300	+/-0.010	0.310	✓			
0.063 x 45°	+/-0.010	0.055x45°	✓			
Ø1.000	+/-0.010	0.999	✓			

Measured by: DJP	Audited by: [Signature]	Prototype Approval:	N/A
Date: 10/03/02	Date: 10.03.02	Date:	N/A

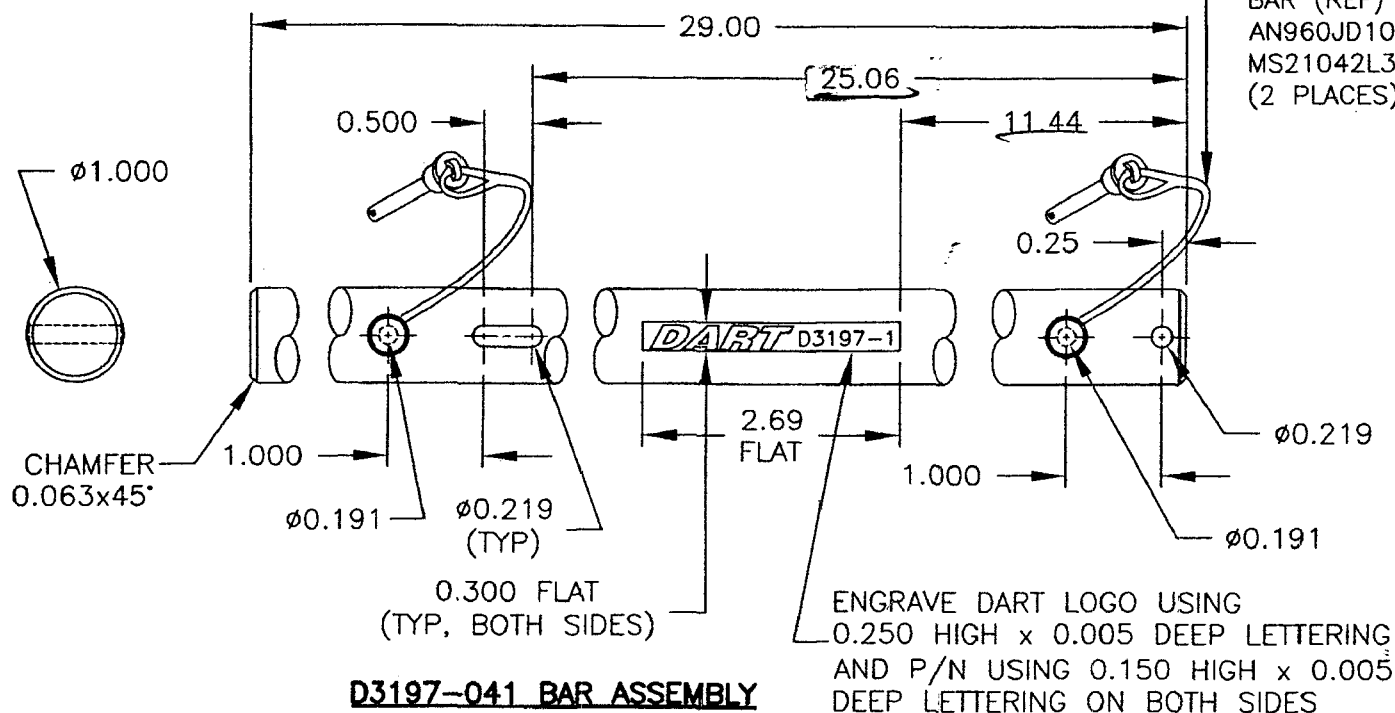
Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3197-041)	KJ/JLM	
B	07.03.09	Dwg revision update	KJ/JLM [Signature]	[Signature]



RELEASED

**DART**

D3489-3-200 PIP PIN (1)  
D3242-1 TAG (1)  
MS27039-1-24 BOLT (1)  
AN960JD10 WASHER (1)  
D2690-5 LANYARD (1)  
AN960JD10 WASHER (1)  
BAR (REF)  
AN960JD10 WASHER (1)  
MS21042L3 NUT (1)  
(2 PLACES)



**D3197-041 BAR ASSEMBLY**

**D3197-1 BAR**

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9)  $\phi$ 1.000 O.D. (REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	TITLE	BAR	DRAWING NO. D3197
		SCALE	1:1	REV. B
				SHEET 1 OF 1
				CHG PIP PIN; ADD D3242-1 TAG
				NEW ISSUE
				03.07.01
				06.01.10
				B

3/0 50546